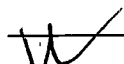
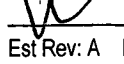


Date: Thursday, 10/08/2006 10:04:24 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAR
Job Number	: 28141		
Estimate Number	: 10388		
P.O. Number	: N/A	Part Number	: D31963
This Issue	: 10/08/2006 S.O. No. : N/A	Drawing Number	: D3196 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 26930	Material	: N/A
Written By	: 	Due Date	: 31/08/2006
Checked & Approved By	: 	Qty:	12 Um: Each
Comment	: Est Rev: A New Issue 05-11-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
-----	--------------------	-------------------------



Comment: Qty.: 3.0345 f(s)/Unit Total : 36.4140 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)
(M6061T6B0.750x01.500)

Identify for D3196-3

Batch: M10100007PCS

M101875/4PCS

J.F. 06/08/22 (11)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank: (0.75" x 1.50") x 34.750" long Bar

J.F. 06/08/22 (11)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3196-3 as per Folio FA339 and Dwg D3196 Identify as D3196-3

2-Deburr

ml/J.F. 06/08/22 1A

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/08/24 10

5.0	QC8	SECOND CHECK
-----	-----	--------------






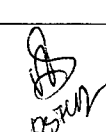
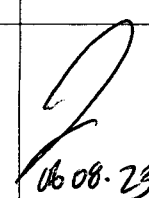
Comment: SECOND CHECK

MS 06/08/24 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/08/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/23	3	Hole is not center. Turn the piece on the wrong side. on 1st part. HUMAN error.		Scrap: destroy No mat'l to replace	 J.F. 06/08/23	 06-08-23		 06-08-23

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:04:24 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 28141

Part Number: D31963

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-08-24

(10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m 06-08-30

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/1/30

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6/1/30

(10)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/30

(10)

Job Completion



C Loc 102/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

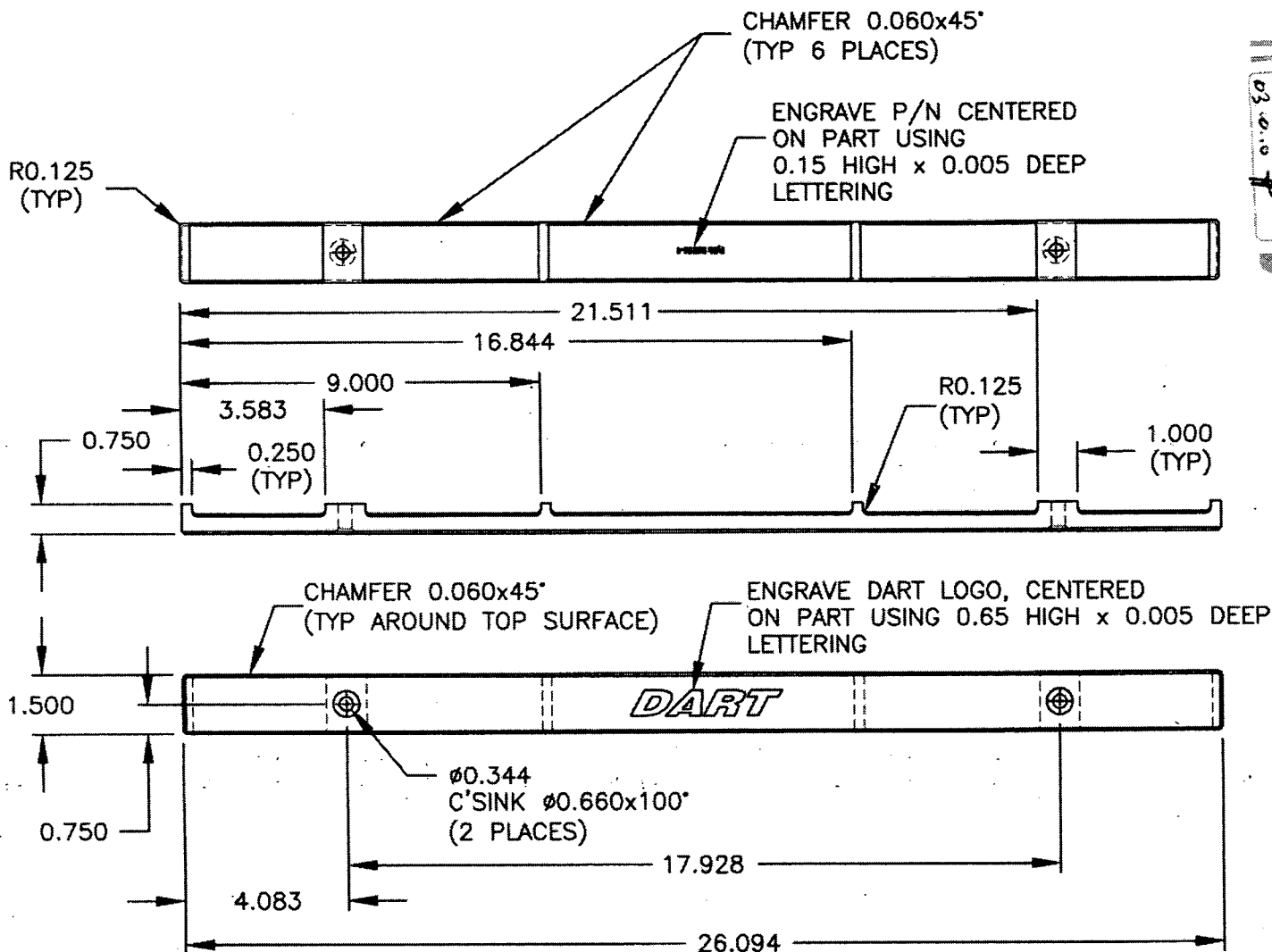
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTRELEASED
03.06.25

DESIGN	03.06.25	DRAWN BY	03.06.25	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		REV. A
DATE	03.06.25	DRAWING NO.	D3196	SHEET 1 OF 3
		TITLE	BAR	SCALE
A		NEW ISSUE		1:4

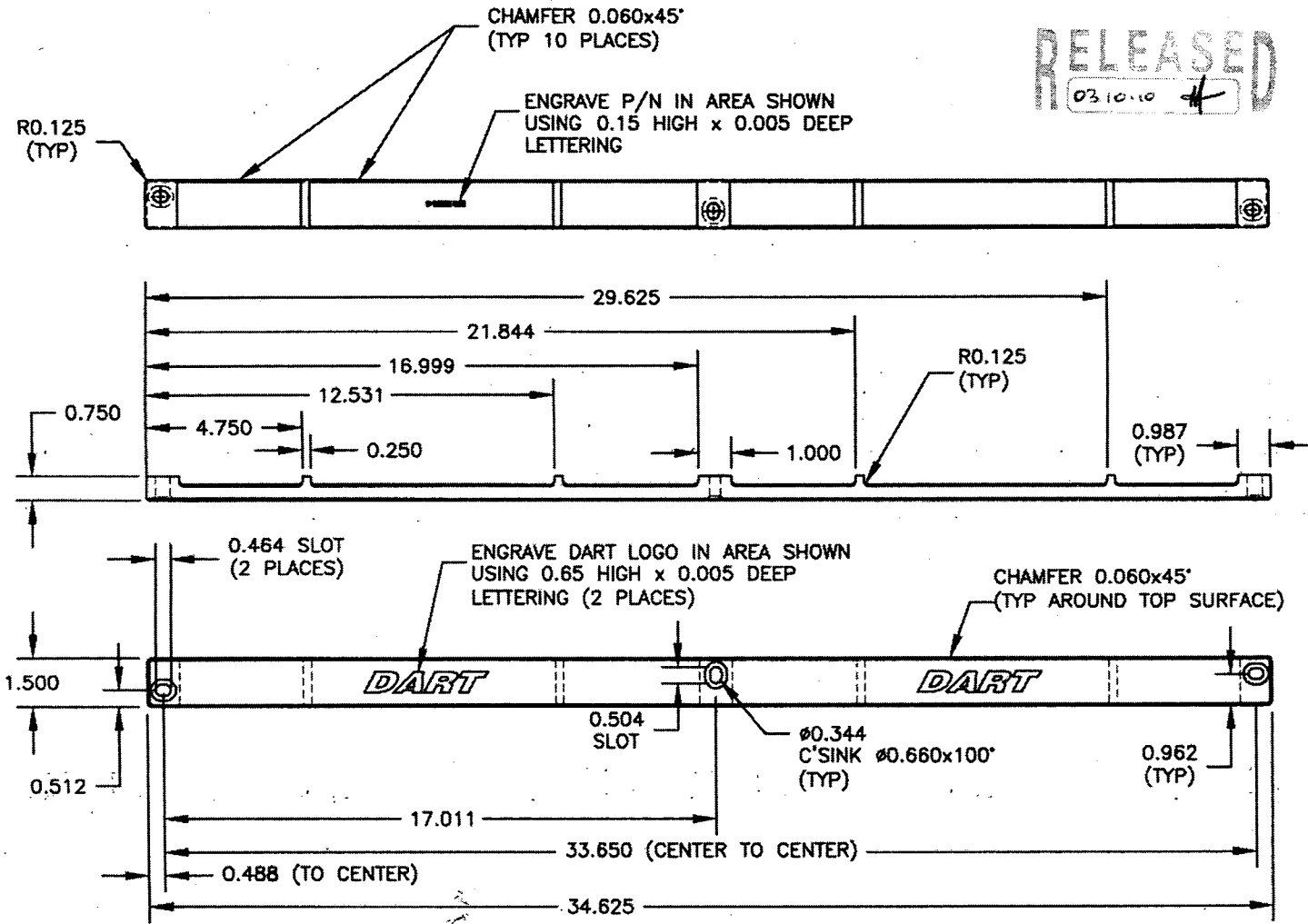
**D3196-1 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED
03.10.10

DART

QA COPY ISSUED

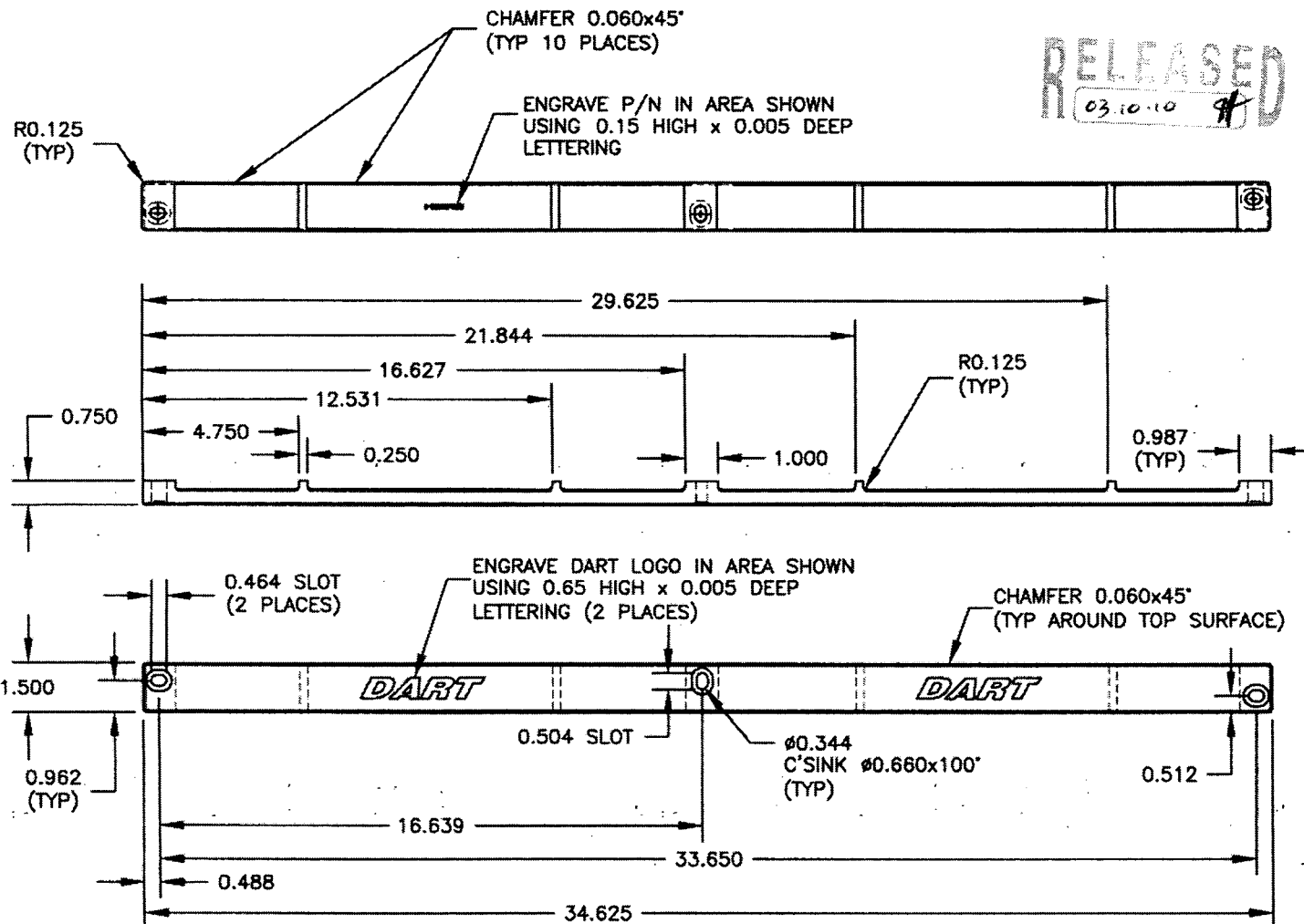


D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
03.06.25	D3196	SHEET 2 OF 3
	TITLE	SCALE
	BAR	1:5

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D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED
03.10.10

DART

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
03.06.25	D3196	SHEET 3 OF 3
	TITLE	SCALE
	BAR	1:5

DART AEROSPACE LTD		Work Order:	
Description: Bar		Part Number:	D3196-3
Inspection Dwg: D3196 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625"	✓			
33.650	+/-0.005	33.650"	✓			
0.488	+/-0.005	.488"	✓			
17.011	+/-0.010	17.011"	✓			
0.512	+/-0.005	.510"	✓			
1.500	+/-0.010	1.498"	✓			
0.464	+/-0.010	.464"	✓			
0.504	+/-0.010	.501"	✓			
Ø0.344	+0.005/-0.000	Ø.347"	✓			
Ø0.660 x 100°	+/-0.005	Ø.663x100°	✓			
0.962	+/-0.005	.961"	✓			
0.750	+/-0.010	.745"	✓			
4.750	+/-0.010	4.745"	✓			
12.531	+/-0.010	12.531"	✓			
16.999	+/-0.010	16.999"	✓			
21.844	+/-0.010	21.844"	✓			
29.625	+/-0.010	29.625"	✓			
0.250	+/-0.010	.253"	✓			
1.000	+/-0.010	1.003"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.987	+/-0.010	0.991"	✓			
0.060 x 45°	+/-0.010	.055" x 45°	✓			

Measured by: J.F.	Audited by: SD	Prototype Approval: N/A
Date: 06/08/23	Date: 06.08.23	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-017)	KJ/RF	